

## Tennessee Pollution Prevention Partnership Success Story



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## Corrugated Recycling Generates Positive Cash Flow

### The Member

Marvin Windows and Doors of Ripley is a family-owned business with corporate offices located in Warroad, MN. The Ripley facility was opened in 1980 and has grown to 680 associates primarily on the day shift. When you visit the Marvin facility, you find a certain type of individual: independent, hard working, and strong in character and conviction. It's certainly why some of Marvin's greatest innovations come from their employees. At this location, Marvin produces a high-end door product, including the "storm plus" designed to meet severe weather codes, for residential and commercial applications. Each door assembly is built to order and promptly shipped on Marvin's own fleet with no finished goods inventory maintained in a warehouse. At Marvin's Ripley facility, Continuous Improvement tools are extensively utilized to be the "best in class", and every job is performed one way: right. For the past three years, the Marvin Ripley facility has been a TOSHA STAR facility under the Voluntary Protection Program and wants to be known as a great place to work and the "employer of choice" in Ripley. This dedication may never make Marvin the biggest window and door manufacturer in the world, but we believe it makes us the best.

### The Story

In the past, the Marvin Ripley facility's white paper and corrugated cardboard ended up in the landfill because it was the most convenient method of handling. It was not, however, what the company environmental management team wanted. After a number of unsuccessful attempts at recycling, the team developed a system that really works. In early 2003, an arrangement was made with a local company to

park a trailer on-site for personnel to fill with paper and cardboard to be hauled away at two-week intervals. Satellite accumulation spots were established at packaging waste generation points and in the office. A system was established to have the paper products taken to the trailer instead of the trash compactor.

### The Success

A year and a half into the project, it is estimated that the Marvin Ripley facility is recycling greater than 95% of its office paper and 65% of its corrugated. Additionally, all production glass received by the facility is in returnable containers, further reducing the amount of packaging received. E-mail is the preferred method of communication at the Ripley facility, thus reducing the amount of white paper used, stored, and disposed. The combination of all revised procedures netted the facility a twenty-five percent reduction in landfill costs in 2003 as compared with the same period in 2002, while simultaneously adding positive dollars to the plant operating income.

### The Pollution Prevented

In 2003, the Marvin Ripley facility had a \$1,500 landfill cost avoidance and received \$1,115 for their used paper and cardboard, netting a positive cash flow of \$2,615, while diverting an estimated twelve trash compactor loads from the landfill. Business in 2004 is up significantly from 2003, and we anticipate that the recycling impact will be even greater this year.

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